

Work Order ID 81786

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81786

Page 1

Item ID: D206-642-311BL

Accept

N9000040100

Setup Start ***NS1***

Revision ID:

Item Name: Skidtube LH

Stop ***NS2***

Start Date: 19/03/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 15/06/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: MLT

Date: 12/03/12

Tooling:

Date:

QC: _____

Date:

SPC (Y/N): _____

Date:

Run Start ***NR1***

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
----------	--------------

D206-642	Rev N
----------	-------

100

0.00

100

DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile and create labels per PPP D206-642-311 CHG006

JB 5 12/6/14 *for MLT 12-5-8*

110

Pick Kit

0.00

110

Packaging

Memo

0.00

Packaging

12/05/08 JB

120

QC4- 100% Inspect kits for completeness

0.00

120

QC

Memo

0.00

Quality Control

5 12/5/11

(Handwritten mark)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

Item ID: D206-642-311BL

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Skidtube LH

Start Date: 19/03/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 15/06/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00							
130	Packaging								
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D206-642-311								
	Location: _____								
	PPP Rev: _____								
140		0.00							
140	QC21- Final Inspection - Work Order Release								
QC	Memo	0.00							
Quality Control									

12/05/11

12/5/16

ME 12-05-15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID: 81786

81786

Parent Item: D206-642-311BL

*D206-642-311RI *

Parent Item Name: Skidtube LH

Start Date: 19/03/2012

Required Date: 15/06/2012

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:J05.10.11Added D3429-1 per CHG004KJ/CP/ILM/EC
IPP Rev:K 07-12-04 ECN 1080p DD verified by:ec
IPP Rev:L 08-09-29 as per DS19421 DD verified by:EC IPP Rev:M
as per REV.N DD 10.04.19 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D206-642-341

Manufactured

No

110

Each

3.0000

1

**

81779

440711

D206-642-341

Replacement Skidtube

Location

Loc Qty

Loc Code

FG081

1

57156

0

57160

0

57161

0

69950

1

FG082

2

36550

1

69952

1

D206-648-013

Manufactured

No

110

Each

25.0000

1

**

93

12/05/08

D206-648-013

GHW Modification

CHG002

Location

Loc Qty

Loc Code

FG

5

78875

5

FG120

16

65455

0

66633

0

81332

16

FG125

4

78874

4

81332

ATTN: D3414-041 - BLUE

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Work Order ID: 81786

Parent Item: D206-642-311BL

Parent Item Name: Skidtube LH

81786

***D206-642-311BL ***

Start Date: 19/03/2012

Required Date: 15/06/2012

Start Qty: 1.00

Required Qty: 1.00

D2932-1
D2932-1
Saddle LH Out, 206

Manufactured No

110 Each

18.0000

**

81801 JB

Location	Loc Qty	Loc Code
ST421	6	
79223	6	
ST428	12	
73466	2	
75096	6	
78968	4	

BLUE
D2933-1
D2933-1
Saddle LH In, 206

Manufactured No

110 Each

7.0000

**

79226 JB

Location	Loc Qty	Loc Code
ST421	6	
79226	6	
ST428	1	
76191	1	

BLUE
D2938-1
D2938-1
Saddle LH Out, 206

Manufactured No

110 Each

14.0000

**

81805 JB sec 12/05/08

Location	Loc Qty	Loc Code
ST421	6	
79228	6	
ST428A	8	
74605	3	
75098	5	

BLUE

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Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Work Order ID: 81786

Parent Item: D206-642-311BL

Parent Item Name: Skidtube LH

81786

*D206-642-311BL *

Start Date: 19/03/2012

Required Date: 15/06/2012

Start Qty: 1.00

Required Qty: 1.00

D2939-1

Manufactured No

110

Each

8.0000

0 1

D2939-1

Saddle LH In, 206

**

81807

CU

Location

Loc Qty

Loc Code

ST421

6

79230

6

ST428A

2

75099

2

BLUE

AN3-41A

Purchased

No

110

Each

467.0000

8 8

AN3-41A

Bolt

**

JB

Location

Loc Qty

Loc Code

ST335

267

120644

267

ST354

200

120498

200

D2652

Manufactured

No

110

Each

692.0000

16 16

D2652

Bushing

**

120498 . s u
3x81953 JB
13 81952 . s u

12/05/08

Location

Loc Qty

Loc Code

FG

44

31985

44

ST013

648

73834

15

73836

36

76134

1

76136

55

77134

400

77136

141

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Work Order ID: 81786

Parent Item: D206-642-311BL

Parent Item Name: Skidtube LH

81786

*D206-642-311BL *

Start Date: 19/03/2012

Required Date: 15/06/2012

Start Qty: 1.00

Required Qty: 1.00

MS21042L3

Purchased

No

110

Each

3,027.000

8

8

**

121349 JB sec

MS21042L3

Nut

Location

Loc Qty

Loc Code

ST300

3027

117441

16

117885

32

118451

5

118927

3

119017

2798

119075

173

AN960JD10

NAS1149D0363J

Purchased

No

110

Each

0.0000

8

8

**

121243 sec

AN960JD10

Washer

AN5-10A

Purchased

No

110

Each

394.0000

4

4

**

JB

AN5-10A

Bolt

Location

Loc Qty

Loc Code

ST337

394

118191

80

120630

50

120717

50

120770

214

AN5-11A

Purchased

No

110

Each

749.0000

4

4

**

JB 12/05/08

AN5-11A

Bolt

Location

Loc Qty

Loc Code

ST337

749

118191

13

119512

736

119512 sec

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Work Order ID: 81786

Parent Item: D206-642-311BL

Parent Item Name: Skidtube LH

81786

*D206-642-311BL *

Start Date: 19/03/2012

Required Date: 15/06/2012

Start Qty: 1.00

Required Qty: 1.00

AN960JD516 NAS1149D0563J Purchased

No

110

Each

0.0000

8

8

X

AN960JD516

Washer

**

119546 JB S.C.

AN4-6A

Purchased

No

110

Each

1,637.000

12

12

X

AN4-6A

Bolt

**

JB

Location

Loc Qty

Loc Code

ST356

1637

119017

1637

14.0000

25

25

X

AN960JD416 NAS1149D0463J Purchased

No

110

Each

AN960JD416

Washer

**

121255 JB S.C.

Location

Loc Qty

Loc Code

ST351

14

116289

14

5,507.000

12

12

X

MS210421-4

Purchased

No

110

Each

MS210421-4

Nut

**

JB 12/05/08

Location

Loc Qty

Loc Code

ST300

5507

117441

51

117601

157

118451

133

119017

200

119075

2966

121011

2000

121011 S.C.

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Pieclist Print

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Work Order ID: 81786

Parent Item: D206-642-311BL

Parent Item Name: Skidtube LH

81786

***D206-642-311RI ***

Start Date: 19/03/2012

Required Date: 15/06/2012

Start Qty: 1.00

Required Qty: 1.00

D3407-043

-Manufactured No

110 Each

43.0000



1

JB

D3407-043

Tow Ring

Location

Loc Qty

Loc Code

ST420

16

79232

16

79232 S

ST463

26

68339

2

74519

9

78841

15

ST464

1

68339

0

71040

1

BLUE

D3456-1

Manufactured No

110 Each

82.0000



1

JB

D3456-1

Washer

81876 JB 12/05/08

Location

Loc Qty

Loc Code

FG

7

25701

7

ST034

12

77486

12

ST044

63

66848

3

71165

2

73493

8

80252

50

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Pieclist Print

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Work Order ID: 81786

81786

Parent Item: D206-642-311BL

***D206-642-311RI ***

Parent Item Name: Skidtube LH

Start Date: 19/03/2012

Required Date: 15/06/2012

Start Qty: 1.00

Required Qty: 1.00

D3457-1

Manufactured No

110 Each

59.0000

D3457-1
Washer

****** **2** **2** **81977 JB** **sn**

Location

Loc Qty

Loc Code

FG

10

32409

10

ST044

49

67779

1

76231

7

78801

41

MS21043-4

Purchased No

110 Each

1,119.000

MS21043-4
Nut

****** **1** **1** **121162 JB** **sn**

Location

Loc Qty

Loc Code

FG

40

104603

40

ST301

1079

119546

370

120308

709

AN4C5A

Purchased No

110 Each

268.0000

AN4C5A
BOLT

****** **0** **1** **JB** **12/05/08**

Location

Loc Qty

Loc Code

ST355

268

112243

168

119017

100

AN960C416

NAS1149C0463

Purchased No

110 Each

0.0000

AN960C416
washer

****** **0** **1** **119017 JB** **sn**
119097 JB

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Page 7

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Picklist Print

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Work Order ID: 81786

Parent Item: D206-642-311BL

Parent Item Name: Skidtube LH

81786

***D206-642-311BL ***

Start Date: 19/03/2012

Required Date: 15/06/2012

Start Qty: 1.00

Required Qty: 1.00

D3413-1

Manufactured No

110

Each

78.0000

**

1

D3413-1

Ring

JB

Location

Loc Qty

Loc Code

ST420

21

70773

1

79233

20

79233

ST464

57

76754

33

77940

2

80224

22

BLUE

D2712

Manufactured No

110

Each

802.0000

**

10

D2712

Set Screw

JB

Location

Loc Qty

Loc Code

FG

50

29962

50

ST017

500

79585

500

79585

ST021

252

76065

252

D2934

Manufactured No

110

Each

88.0000

**

2

D2934

Saddle Spacer

JB

12/05/08

Location

Loc Qty

Loc Code

FG

6

31929

6

ST021

82

74883

28

78802

54

78802

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID: 81786

Parent Item: D206-642-311BL

Parent Item Name: Skidtube LH

81786

*D206-642-311BL *

Start Date: 19/03/2012

Required Date: 15/06/2012

Start Qty: 1.00

Required Qty: 1.00

D2935

Manufactured No

110

Each

116.0000

**

2

JB

12/05/08

D2935
Saddle Spacer

Location

Loc Qty

Loc Code

FG

6

31793

6

ST021

110

74882

26

78807

84

78807

S

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

4.5 206 L/L-1/L-3/L-4/407 LOW & HIGH GEAR SKIDTUBES

ITEM	QTY -311	QTY -312	QTY -313	QTY -314	QTY -341	QTY -347	QTY -349	QTY -351	QTY -013	PART NUMBER	DESCRIPTION
	X									D206-642-311	SKIDTUBE INSTALLATION, LH
		X								D206-642-312	SKIDTUBE INSTALLATION, RH
			X							D206-642-313	SKIDTUBE INSTALLATION, LH
				X						D206-642-314	SKIDTUBE INSTALLATION, RH
1	1	1			X					D206-642-341	SKIDTUBE
						X				D206-642-347	WEARSHOE KIT (REPLACES -343)
							X			D206-642-349	RUN-ON LANDING WEARPLATE KIT
			1	1				X		D206-642-351	SKIDTUBE
	1	1	1	1					X	D206-648-013	GROUND HANDLING KIT
1					1					D2650-5	SKIDTUBE ASSEMBLY
1								1		D4361-041	SKIDTUBE ASSEMBLY
2A					14			4		D2651-1	* PLUG ⁽¹⁾
2B					14			4		D2651-3	* O-RING ⁽¹⁾
3					1			1		D2646	* AFT CAP ⁽¹⁾
4					2			2		MS27039-1-08	* SCREW ⁽¹⁾
5					2			2		NAS1149D0332J	* WASHER ⁽¹⁾ (OR AN960JD10L)
6	1		1							D2932-1	SADDLE, FWD OUT, LH
6		1		1						D2932-2	SADDLE, FWD OUT, RH
7	1		1							D2933-1	SADDLE, FWD IN, LH
7		1		1						D2933-2	SADDLE, FWD IN, RH
8	1		1							D2938-1	SADDLE, AFT OUT, LH
8		1		1						D2938-2	SADDLE, AFT OUT, RH
9	1		1							D2939-1	SADDLE, AFT IN, LH
9		1		1						D2939-2	SADDLE, AFT IN, RH
10	8	8	8	8						AN3-41A	BOLT
11	16	16	16	16						D2652	BUSHING
12A	8	8	8	8						MS21042-3	NUT (OR MS21042L3)
12B	8	8	8	8						NAS1149D0363J	WASHER (OR AN960JD10)
13	4	4	4	4						AN5-10A (OR AN5-11A)*	* BOLT ⁽²⁾
14	4	4	4	4						AN5-11A (OR AN5-12A)	* BOLT ⁽²⁾
15	8	8	8	8						NAS1149D0563J	WASHER (OR AN960JD516)
16	12	12	12	12						AN4-6A	BOLT
17	24	24	24	24						NAS1149D0463J	WASHER (OR AN960JD416)
18	12	12	12	12						MS21042-4	NUT (OR MS21042L4)
20A					6	6				D3537-1	WEARPAD (REPLACES D2648-3)
21A					1	1				D3537-3	WEARPAD (REPLACES D3429-1)
22A					1	1				D3535-11	WEARSHOE (REPLACES D2656-11)
22B					1	1				D3536-11	GASKET
23A					1	1				D3535-23	WEARSHOE (REPLACES D2656-23)
23B					1	1				D3536-23	GASKET
24A					1	1				D3535-35	WEARSHOE (REPLACES D2656-35)
24B					1	1				D3536-35	GASKET
26A					54	54				MS27039C1-08	SCREW
26B					54	54				NAS1149C0332R	WASHER (OR AN960C10L)
26C					54					ALS7-1032-130	* INSERT ⁽¹⁾ (or AKS4-1032-130, ALS4-1032-130, AELS-1032-130)
30	1	1	1	1						D3407-043	TOW RING ASSEMBLY (REPLACES D2968-043)
31	1	1	1	1						D3456-1	WASHER
32	1	1	1	1						D3457-1	WASHER
33	1	1	1	1						MS21043-4	NUT
34	1	1	1	1						AN4C5A	BOLT
35	1	1	1	1						NAS1149C0463R	WASHER (OR AN960C416)
36	1	1	1	1						D3413-1	RING (REPLACES D2655)
37	10	10	10	10						D2712	SET SCREW
38	2	2	2	2						D2934	SADDLE SPACER
39	2	2	2	2						D2935	SADDLE SPACER
40									2	D3414-041	GHW LUG (REPLACES D2659)
41									4	AN3C37A	BOLT
42									8	D2652	BUSHING
43									4	MS21043-3	NUT
44									4	NAS1149C0363R	WASHER (OR AN960C10)

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ITEM	QTY -311	QTY -312	QTY -313	QTY -314	QTY -341	QTY -347	QTY -349	QTY -351	QTY -013	PART NUMBER	DESCRIPTION
50							1	1		D4364-041	FWD WEARPLATE ASSY
51							1	1		D4364-043	AFT WEARPLATE ASSY
52							18	18		D3873-1	BUSHING
53							4			D2649	SPACER
54A							9	9		AN3-36A	BOLT
54B							9	9		NAS1149C0332R	WASHER (OR AN960C10L)
54C							9	9		MS21042-3	NUT

NOTES: (1) DENOTES THAT PART IS INCLUDED WITH D2650-5 OR D4361-041 ASSEMBLY ABOVE
(2) CHOICE OF BOLT WILL DEPEND ON CROSSTUBE (SEE INSTALLATION PROCEDURE)

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